

Date: Wednesday, 21/05/2008 4:10:33 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 03.250 SUPPORT
Job Number	: 39390		
Estimate Number	: 10387		
P.O. Number	:	Part Number	: D29401
This Issue	: 21/05/2008 S.O. No. :	Drawing Number	: D2940 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 38128	Material	:
Written By	:	Due Date	: 06/06/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JUD 08.5.21</u>		
Comment	: Est. C 02.11.26 Reformat; Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM est E 08.03.19 Re-format Ec verified by DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK081	D2940-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)
 D2940-1 TURNING DETAIL
 Batch: B 38134

J.F. 08/06/12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS
 1- Machine as per Folio FA079
 2- Tumble & Deburr

J.L./J.F. 08/06/12

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L./J.F. 08/06/12

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08.06.12

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3
 *****Mask Inside Surface as per Dwg D2940*****

START TIME: 7:05 AM
 OVEN TEMPERATURE: 400 °F
 FINISH TIME: 7:35 AM

JH 08-06-20 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/05/2008 4:10:33 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 39390

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

ml 08 07 07

(x20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RT 08-07-11 (x20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

X tube assy

RT 08-07-11 (x20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/14

Job Completion



mf 08-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39390
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.151	.150	.151	.151	.151
AD	3.510	3.530		3.515	3.525	3.521	3.522	3.524
AE	1.633	1.673		1.657	1.658	1.657	1.657	1.655
AF	1.493	1.513		1.510	1.505	1.503	1.504	1.505
AG	0.040	0.060		.055	.049	.048	.049	.048
AH	0.188	0.193		.190	.190	.190	.190	.190
AI	0.140	0.160		.151	.150	.150	.150	.147
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.051	.050	.050	.050	.050
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.153	.148	.152	.148	.147
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.150	.150	.151	.151	.156
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.265	.263	.263	.264	.263
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.129	4.127	4.128	4.128	4.132
AV								
AW								
Accept/Reject								

Measured by: J.L. / 12/18	Date: 08/06/05
Audited by: J.L. / 08.06.18	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	39390
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

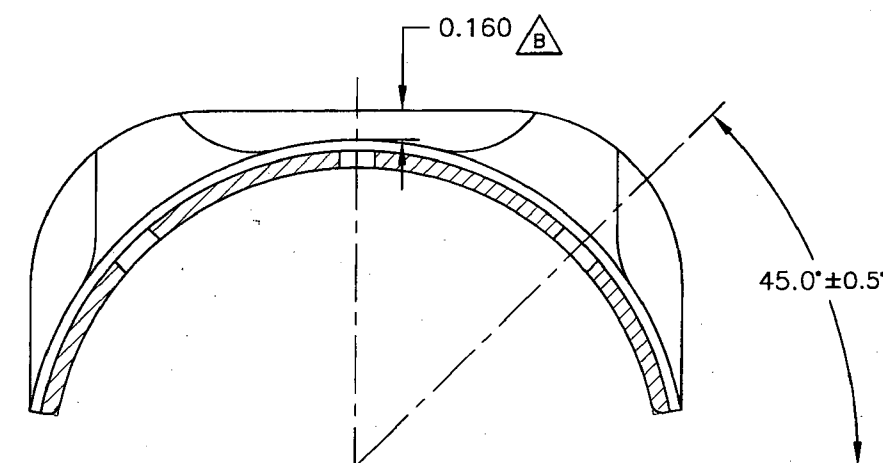
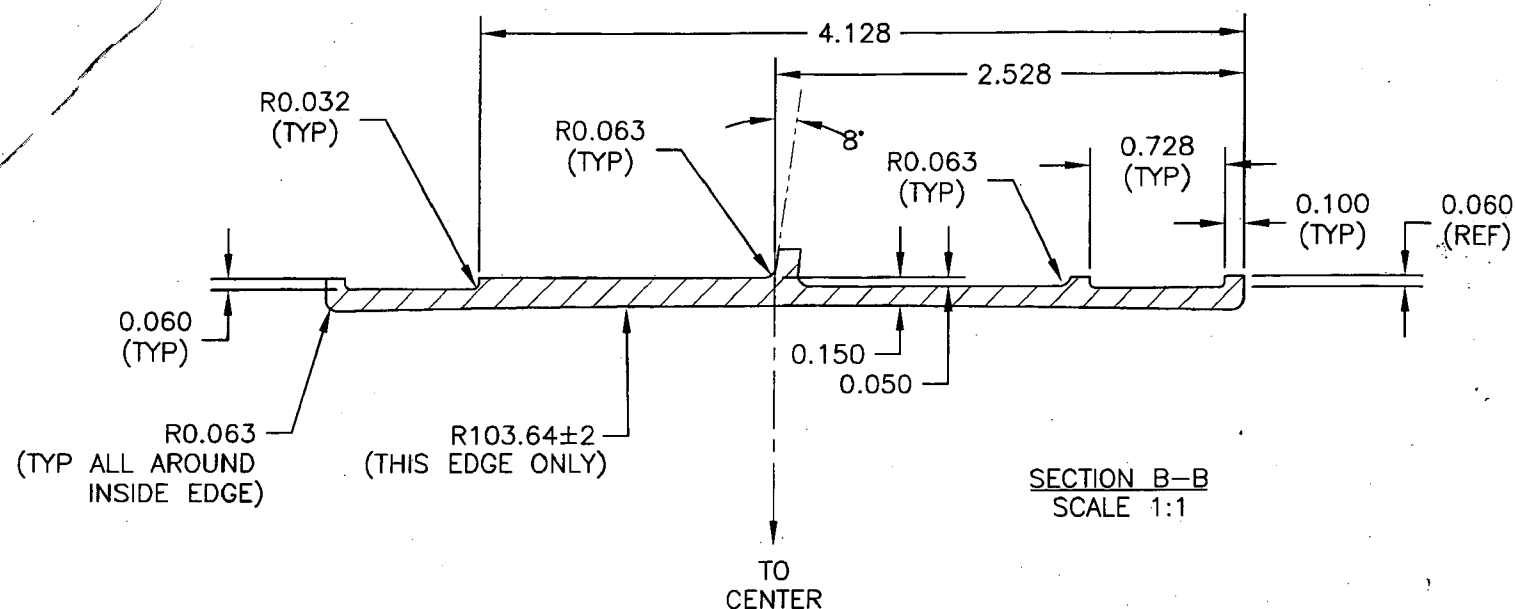
☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	R.250"	A.250"
AB	0.490	0.510		.500	.500	.500	A.500"	A.500"
AC	0.140	0.160		.154	.152	.152	.153"	.153"
AD	3.510	3.530		3.525	3.525	3.525	3.525"	3.525"
AE	1.633	1.673		1.660	1.640	1.657	1.660"	1.660"
AF	1.493	1.513		1.502	1.504	1.501	1.503"	1.503"
AG	0.040	0.060		.048	.049	.048	.049"	.049"
AH	0.188	0.193		.190	.192	.196	Ø.189"	Ø.189"
AI	0.140	0.160		.146	.147	.147	.151"	.151"
AJ	2.518	2.538		2.530	2.530	2.530	2.530"	2.530"
AK	0.040	0.060		.050	.052	.049	.040"	.040"
AL	0.010	0.020		.015	.015	.015	.015"	.015"
AM	0.140	0.160		.149	.147	.150	.160"	.160"
AN	0.350	0.450		.390	.396	.370	.370"	.370"
AO	0.240	0.260		.250	.250	.250	.250"	.250"
AP	0.150	0.170		.155	.155	.155	.155"	.155"
AQ	0.053	0.073		.063	.063	.063	.063"	.063"
AR	101.64	105.64		103.64	103.64	103.64	103.64"	103.64"
AS	0.260	0.267		.264	.264	.264	Ø.262"	Ø.262"
AT	0.053	0.073		.063	.063	.063	R.063"	A.063"
AU	4.118	4.138		4.136	4.130	4.130	4.134"	4.134"
AV								
AW								
Accept/Reject								

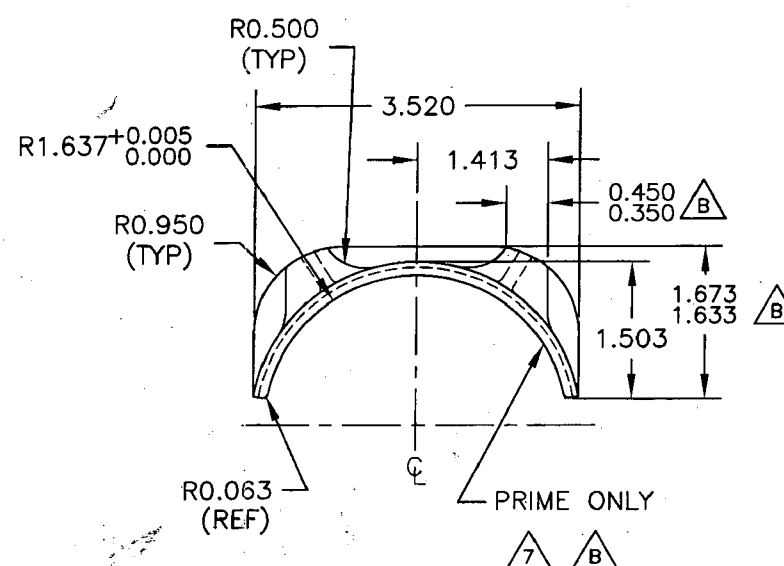
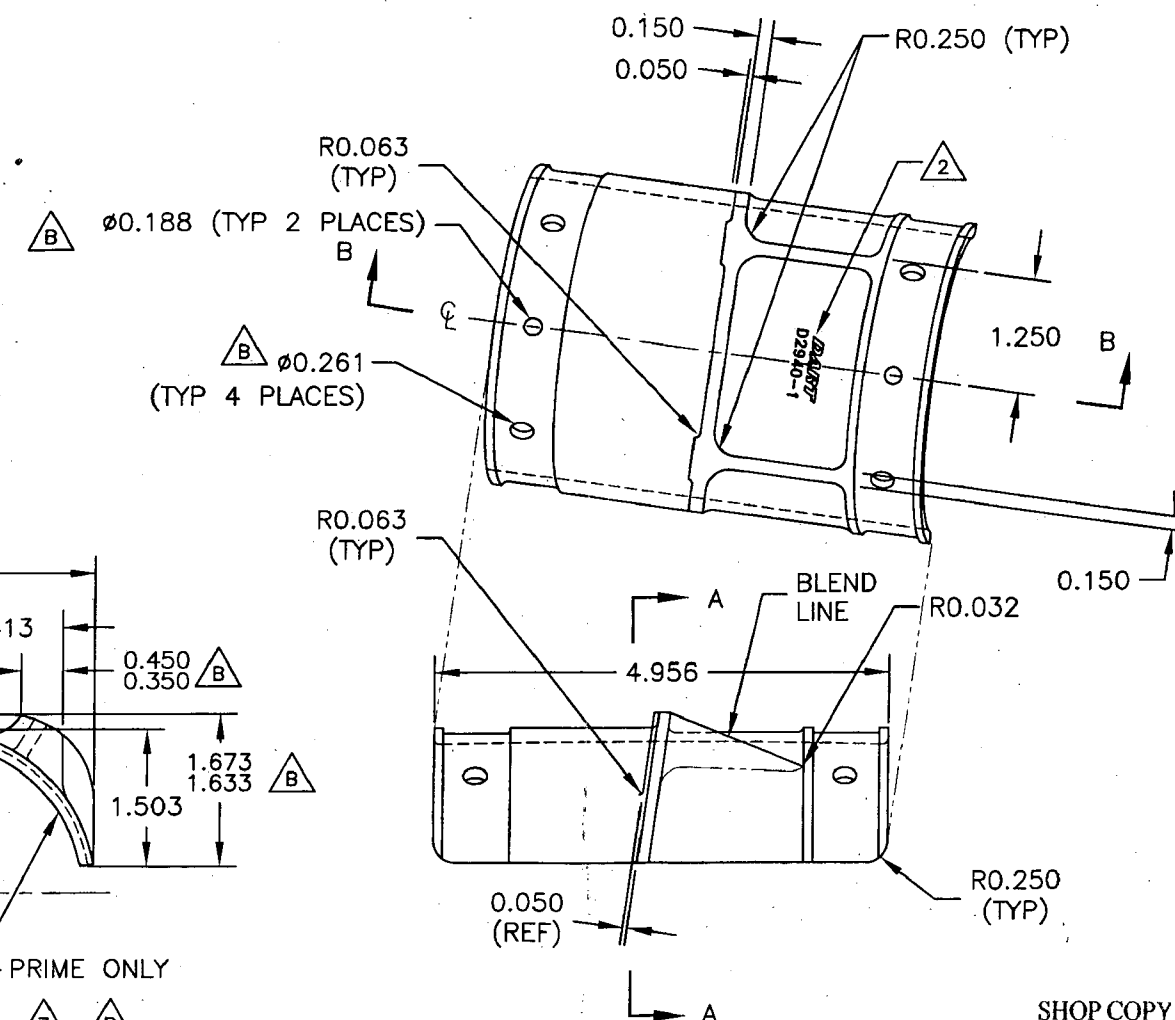
Measured by:	<i>me / J.F.</i>	Date:	08/06/08
Audited by:	<i>[Signature]</i>	Date:	08-06-18
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	<i>[Signature]</i>

RELEASED
 07.04.24 UP
 PER ECN 829



SECTION A-A
 TOOLING HOLE DETAIL
 SCALE 1:1



D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
 HEAT TREAT TO H900 CONDITION
 (900°F FOR 1 HR, AIR COOL)
 MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
 WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
 PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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 WITHOUT NOTICE
 WORK ORDER
 NO. 39390

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 DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D2940
DATE	07.03.16	TITLE Ø3.250 SUPPORT
		REV. B SHEET 1 OF 1 SCALE 1:2